

Date: Monday, 7/9/2007 12:47:08 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : JACK SADDLE
Job Number : 33414	
Estimate Number : 11177	
P.O. Number : N/A	Part Number : D2281
This Issue : 7/9/2007 S.O. No. : N/A	Drawing Number : D2281 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : G
Previous Run : 33258	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 7/30/2007 Qty: 50 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: A Removed from 9 Digit 05-12-02 JLM	
Est: rev B 06.07.17 waterjet EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S14GA	304SS .080
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Comment: Qty.: 0.1313 sf(s)/Unit Total : 6.5625 sf(s)

304SS .080

batch: M101873

M105412 → SAA 07/08/03 (13) 5  
 → HB 07-07-21 (37)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2281

Dwg Rev: G

Prog Rev: G

2-Deburr if necessary

HB 07-07-21

SAA 07/08/03

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Er 07/08/03 (50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Deburr

SAA 07/07/03 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RD Date: 07/08/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:47:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 33414

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

813 07/08/07 (50)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/08/07 (150)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11 07/08/07 (50)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

50 07/08/07

Job Completion



07-08-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	33414
<b>Description:</b> Jack Saddle		<b>Part Number:</b>	D2281
<b>Inspection Dwg:</b> D2281 <b>Rev:</b> G		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.476	*			
4.114	+/-0.010	4.114	*			
2.933	+/-0.010	2.933	*			
1.535	+/-0.010	1.540	*			
0.354	+/-0.010	.354	*			
0.354	+/-0.010	.354	*			
0.604	+/-0.010	.604	*			
2.000	+/-0.010	2.000	*			
3.396	+/-0.010	3.396	*			
3.646	+/-0.010	3.646	*			
4.000	+/-0.010	4.006	*			
1.525	+/-0.010	1.529	*			
2.475	+/-0.010	2.477	*			
Ø0.323	+0.006/-0.001	Ø .322	*			
0.080	+/-0.010	.079	*			

<b>Measured by:</b>	RB	<b>Audited by:</b>	EW	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07-07-21	<b>Date:</b>	07/08/03	<b>Date:</b>	N/A

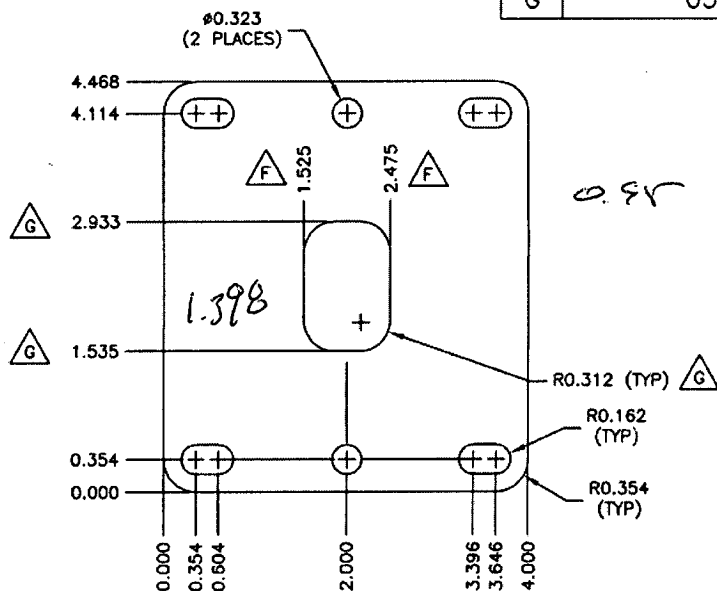
Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	[Signature]



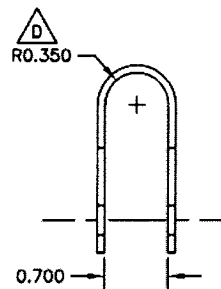
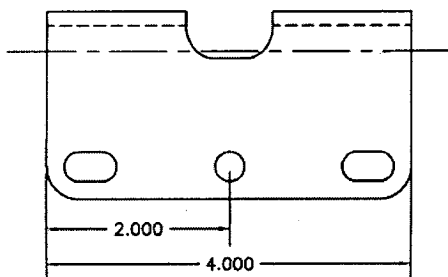
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281 REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE
B	94.10.18	DIMENSION WAS 2.878
C	94.11.04	ADD TOOLING NOTCH
D	98.03.27	R0.350 WAS R0.280
E	04.11.18	REMOVE TOOLING NOTCHES
F	05.03.16	REDESIGN FLAT PATTERN
G	05.06.07	REDESIGN FLAT PATTERN

RELEASED

05/08/11



FLAT LAYOUT



# D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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